Tuesday, 05/06/2007 11:37:11 AM Date: Linda Lacelle User: **Process Sheet Drawing Name** : SPACER : CU-DAR001 Dart Helicopters Services Customer Job Number : 32752 : 10980 **Estimate Number** : D2808 : NA Part Number P.O. Number S.O. No. : NA : D2808 REV A1 **Drawing Number** This Issue : 05/06/2007 : NC Project Number : N/A Prsht Rev. : MACHINED PARTS **Drawing Revision** Type First Issue : 28600 Material Previous Run : 05/06/2007 Each **Due Date** Written By Checked & Approved By : Est Rev:D 02.03.07 Now turned in house Comment **Additional Product** Job Number: Description: Seq. #: M6061T6R0625 6061-T6 Round Bar .625" 1.0 Comment: Qty.: 0.0557 f(s)/Unit 2.2260 f(s) Total: 6061-T6 Round Bar .625" (M6061T6R0625) M8 07/06/05 Batch: M103857 HARDINGE CNC LATHE SMALL 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit) 2-Deburr INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 HC Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK HAND FINISHING RESOURCE #1 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 m 104144

Page 1

Dart A	erospace	Ltd
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W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07/06/0
			Date:
	PAR #:	PAR #: Fault Category:	PAR #: Fault Category: NCR: Yes No DQA: QA: N/C Closed:

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B	3	Verification	Ammunical	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector

NOTE: Date & initial all entries

User:

Tuesday, 05/06/2007 11:37;11 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 32752

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT



7.0

PACKAGING RESOURCE #



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



8.0

QC21

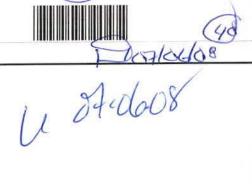
FINAL INSPECTION/W/O RELEASE



Comment: FINAL IN SPECTION/W/O RELEASE

Job Completion





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W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory: NC	R: Yes	No DQ	۸:	_ Date: _	
					QA: N	/C Close	d:	_ Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMANCE	(NCR	2)			
		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	T T
Description: Spacer	Part Number:	D2808
Inspection Dwg: D2808 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.000	191	~			
Ø0.313	+0.005/-0.000	. 316				
Ø0.500	+/-0.005	,498	~			
0.641	+/-0.010	140.	V			
0.359	+/-0.010	.359	~			
0.040 x 45°	+/-0.010	,040	~			
R0.020	+/-0.010	,020	V			

Measured by:	NS.	Audited by:	and	Prototype Approval:	N/A
Date:	orloidos	Date:	07/06/05	Date:	N/A

Rev	Date	Change		pproyed
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W/O:			WORK ORDER C	HANGES				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	Δ.	Date:	

NCR:		ii daadaa aa	WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Vifi4i	Annual	Approval QC Inspecto
DATE :	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspecto

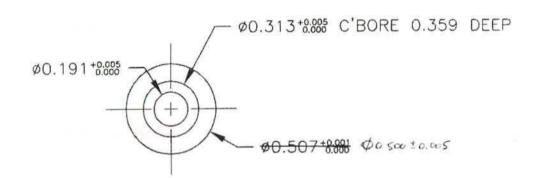
NOTE: Date & initial all entries

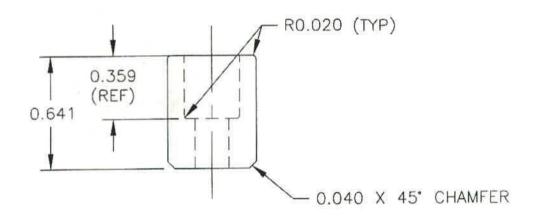
QA: N/C Closed: _____ Date: _____





DESIG	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHEC	KED APPROVED	D2808	REV. A		
DATE OO.	11.07	TITLE SPACER	SCALE 2:1		
А	00.11.07	NEW ISSUE			
Al	110 01.04.26	ADD POWDER COAT ; \$0.500 WAS	60.507		





TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020 MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER LOAT WHITE (435.1) OR GREY SAMDIEX (435.6) OR BLACK SAMDIEX (43.5.7) OR GREEN SANDTEX (4358) PER DART QSI 005 4.3

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W/O:		WORK ORDER CHA	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: _____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE ST		STED Description of NC	Corrective Action Section B			Varification				
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NOTE: Date & initial all entries